

Date: Monday, 22/12/2008 3:06:12 PM
 User: Melanie Fauteux

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	CONSOLE
Job Number :	44254		
Estimate Number :	10910		
P.O. Number :		Part Number :	D33631
This Issue :	22/12/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3363 REV C
First Issue :	/ /	Project Number :	N/A
Previous Run :	38263	Drawing Revision :	C
	Type :	Material :	
	SMALL /MED FAB	Due Date :	20/01/2009
Written By :		Qty:	4
		Um:	Each
Checked & Approved By :	<u>JLD 08.12.23</u>		
Comment :	Est: B 05.09.09 Remove c'sink rivet holes and add welding stepK J/JLM Est: C 06.11.15 waterjet EC Est Rev:D 08-07-14 add comment in QC5 inspection DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 2.4150 sf(s)/Unit Total : 9.6600 sf(s)
 6061-T6 .063 thick aluminum Sheet
 Batch: 108279 IB 9-1-6

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET
 1-Cut as per Dwg D3363 ***CUT AT 45 DEG GRAIN DIRECTION*****
 Dwg Rev: C
 Prog Rev: C IB 9-1-6

(4)

2-Deburr if necessary IB 9-1-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 02/01/06 (xy)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 22/12/2008 3:06:12 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE

Job Number: 44254

Part Number: D33631

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D3363

SB 09/01/18

RTO

(4)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/06

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld using DT8790 as per Dwg D3363 and QSI 004

SP 09-02-20

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-02-25

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1- inspect part with DT8790 jig

S 09/02/06

PKA

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 09/02/26

(4)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/26

Job Completion



mf 09-02-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
2/2/26	# 11.0	Chemical coat as per QS 2005	AA	09/02/26			S 9/2/26	
2/2/26	# 2.0	QC inspect Alodine	AA	09/02/26			S 9/2/26	

Part No: D3367-1 PAR #: _____ Fault Category: _____ D212-22-01 NCR: Yes ☒ No ☐ DQA: D Date: 09/03/03

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>44254</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.01.09	5	Dimension 10.430 is 10.460	RA 09.01.09 QSI 042	ACCEPTABLE DEVIATION NO STRUCTURAL IMPACT	RA 09.01.19 QSI 042	S 09/02/26	RA 09.01.19 QSI 042	S 09/02/26

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 44254
Description: Console		Part Number: D3363-1
Inspection Dwg: D3363	Rev: C	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.102	*			
Ø0.128	+0.005/-0.001	.133	*			
Ø0.469	+0.006/-0.001	.471	*			
14.41	+/-0.030	14.41	*			
14.097	+/-0.010	14.097	✓			
12.409	+/-0.010	12.409	✗			
11.354	+/-0.010	11.353	✗			
10.706	+/-0.010	10.708	✗			
10.081	+/-0.010	10.088	✗			
4.331	+/-0.010	4.336	✗			
3.706	+/-0.010	3.709	✗			
3.058	+/-0.010	3.060	✗			
2.004	+/-0.010	2.003	✗			
2.366	+/-0.010	2.360	✗			
3.100	+/-0.010	3.104	✗			
5.040	+/-0.010	5.038	✗			
5.415	+/-0.010	5.418	✗			
2.25	+/-0.030	2.249	✗			
19.965	+/-0.010	19.965	✗			
20.366	+/-0.010	20.366	✓			
21.318	+/-0.010	21.318	✗			
22.90	+/-0.030	22.900	✗			
0.315	+/-0.010	.315	✗			
3.706	+/-0.010	3.702	✗			
4.025	+/-0.010	4.026	✗			
7.206	+/-0.010	7.210	✗			
1.75	+/-0.030	1.744	✗			
10.387	+/-0.010	10.389	✗			
19.590	+/-0.010	19.590	✓			

DART AEROSPACE LTD		Work Order: 44254
Description: Console		Part Number: D3363-1
Inspection Dwg: D3363	Rev: C	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.990	+/-0.010	18.990	X			
1.80	+/-0.030	1.801	X			
6.390	+/-0.010	6.391	X			
5.790	+/-0.010	5.794	✓			
4.475	+/-0.010	4.474	✓			
4.100	+/-0.010	4.102	✓			
2.725	+/-0.010	2.725	✓			
2.00	+/-0.030	2.004	X			
6.363	+/-0.010	6.357	✓			
10.737	+/-0.010	10.740	✓			
11.206	+/-0.010	11.208	X			
3.206	+/-0.010	3.208	X			
3.675	+/-0.010	3.675	X			

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 9-1-06	Date: 09/01/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	

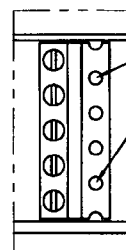
DART

DESIGN	PA1	DRAWN BY	PA1	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.01.26	TITLE	D3363	REV. C
			CONSOLE ASSEMBLY	SHEET 1 OF 3
				SCALE
A	04.11.29		NEW ISSUE	1:5
B	05.03.28		INCREASE WIDTH BY 0.125	
C	07.01.26		T'DRILL DZUS RAIL, WIDEN BASE CUTOUT	

RELEASED

07.06.04

TRANSFER DRILL #30 FROM D3362-1 DZUS RAIL THROUGH D3363-1 CONSOLE (TYP 4 PLACES) C'SINK (#0.225 X 100') FROM TOP SIDE OF CONSOLE



DETAIL C
(SCALE 1:2)

DETAIL C

INSTALL D3361-1 & D3362-1 USING MS20426AD4-6 RIVETS (TYP 9 PLACES)

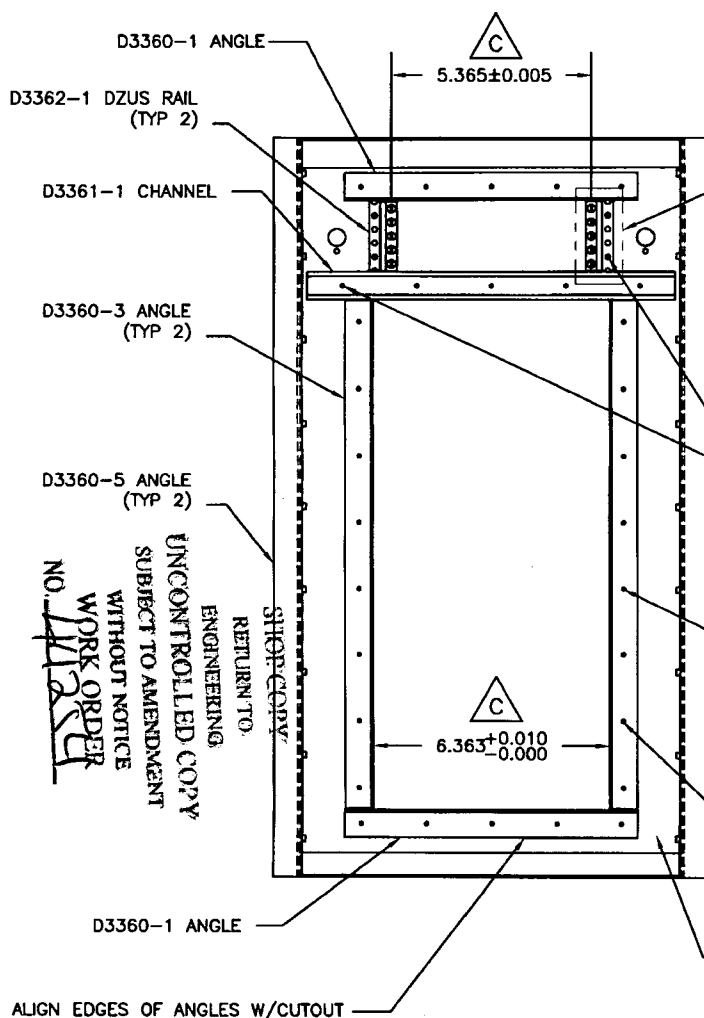
TRANSFER DRILL #30 FROM MATING PARTS THROUGH #40 HOLES IN D3363-1 CONSOLE (TYP 49 PLACES) C'SINK (#0.225 X 100') FROM CONSOLE TOP SIDE

INSTALL D3360-1/-3/-5 ANGLES USING MS20426AD4-5 RIVETS (TYP 44 PLACES)

D3363-1 CONSOLE

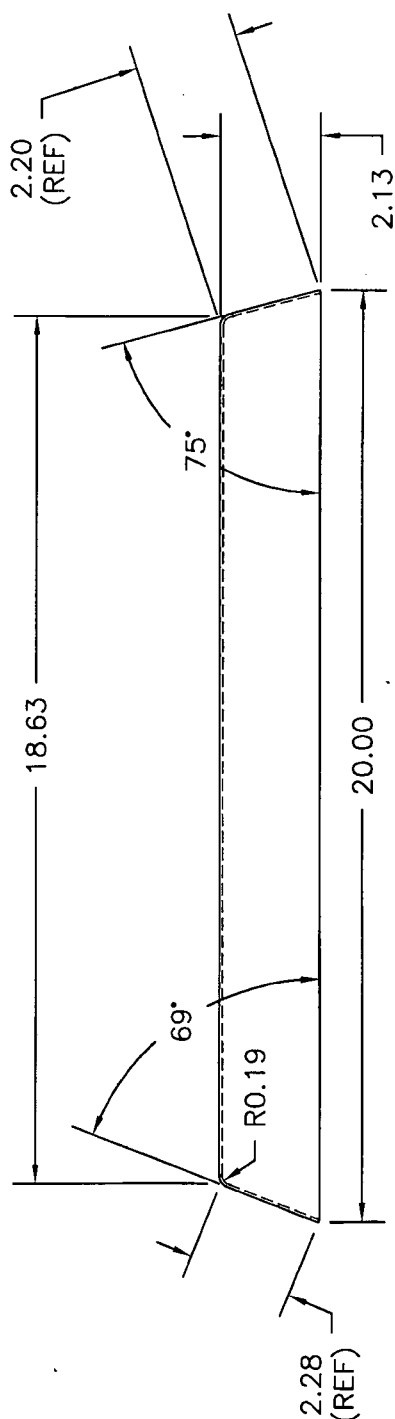
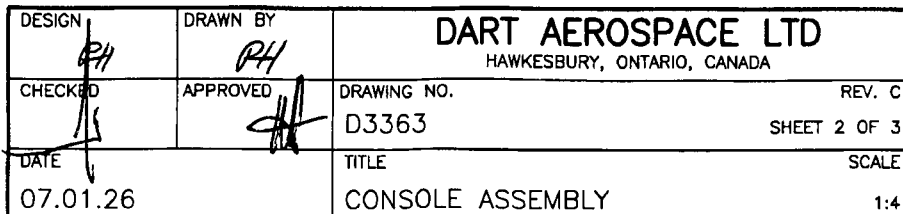
PARTS LIST FOR D3363-041 CONSOLE ASSEMBLY

QTY	PART NUMBER	DESCRIPTION
X	D3363-041	CONSOLE ASSEMBLY
2	D3360-1	ANGLE
2	D3360-3	ANGLE
2	D3360-5	ANGLE
1	D3361-1	CHANNEL
2	D3362-1	RAIL
1	D3363-1	CONSOLE
44	MS20426AD4-5	RIVET
9	MS20426AD4-6	RIVET

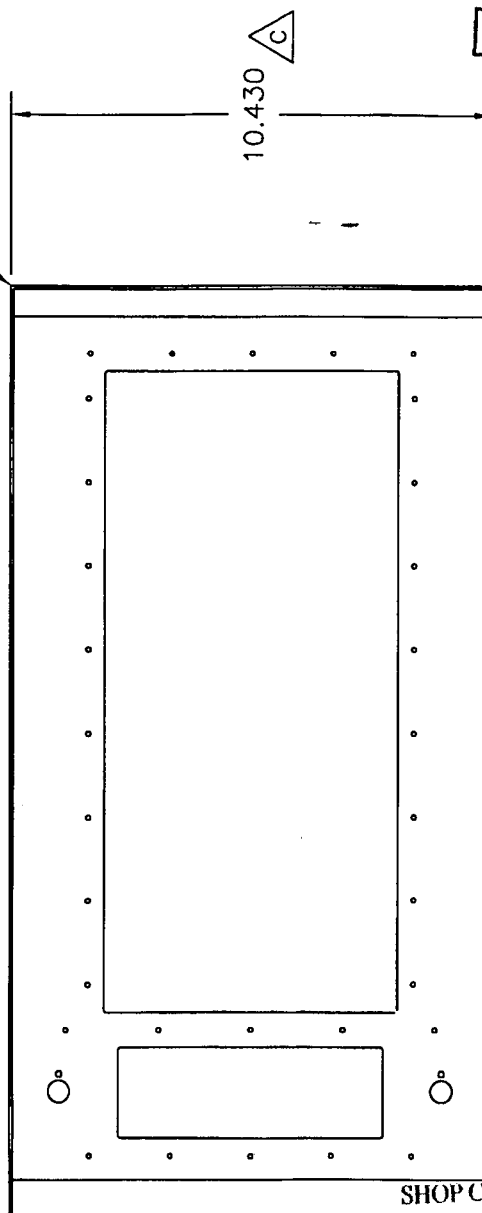


D3363-041 CONSOLE ASSEMBLY

- 1) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
- 2) IDENTIFY WITH DART P/N D3363-041 AND B/N BXXXXX USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1



GRIND OUTSIDE
WELD FLUSH
(TYP 4 PLACES)



RELEASED

07.06.04

D3363-1 BEND DETAIL

(MAKE FROM D3363-1F FLAT PATTERN)

SHOP COPY

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SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

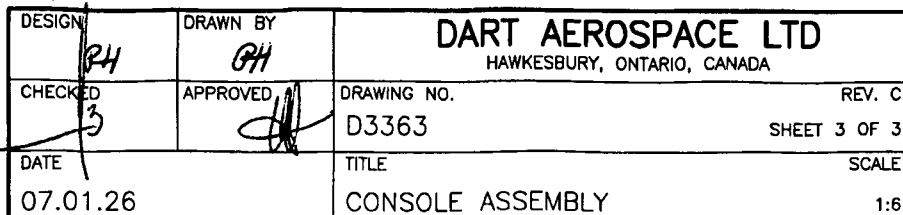
NO. 44254

D3363-1 CONSOLE

- 1) WELD PER DART QSI 004
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

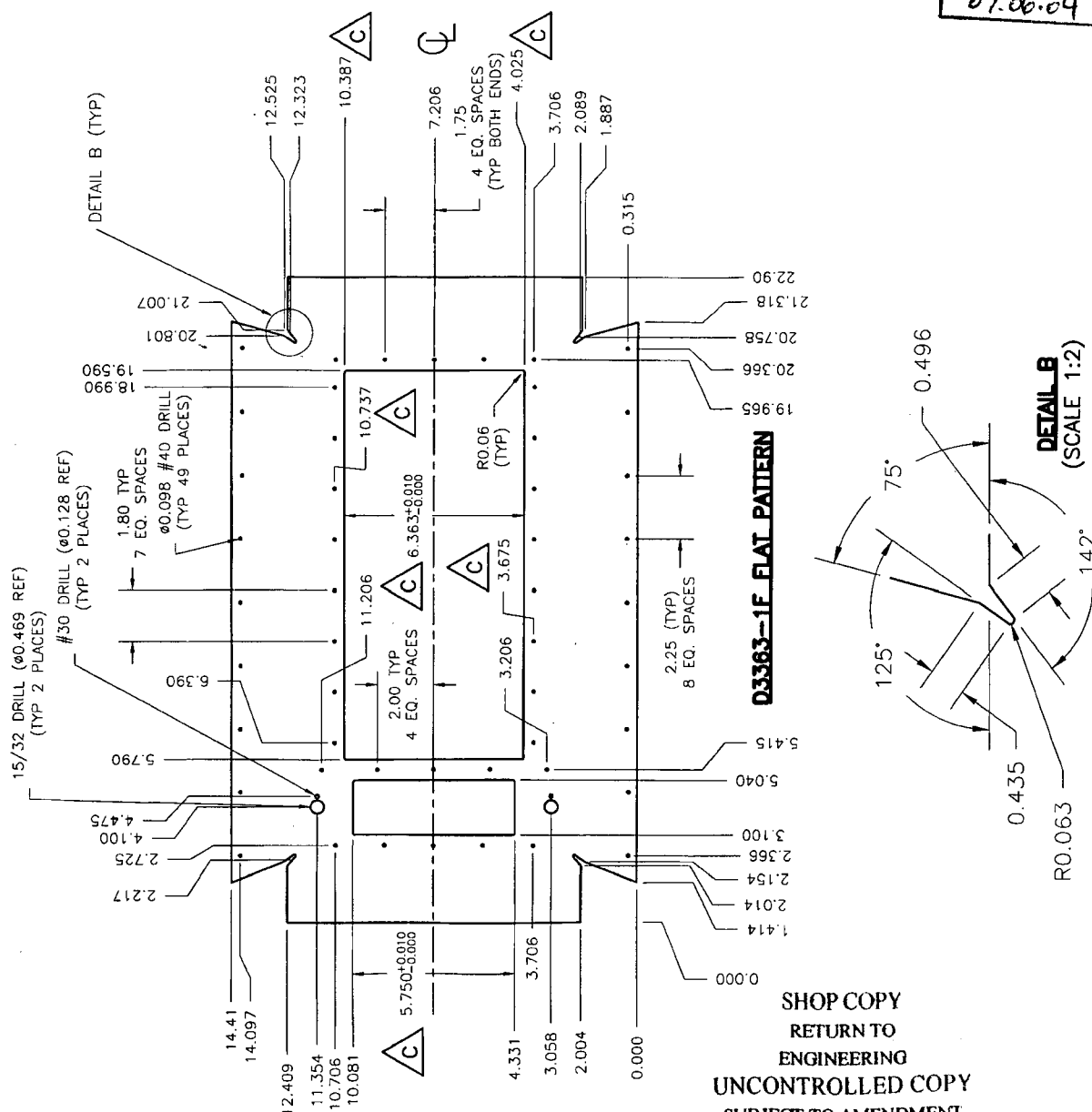
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07.06.04



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D3363-1F CONSOLE (FLAT PATTERN)

- 1) MATERIAL: 6061-T6/T651 ALUMINUM 0.063 THICK
PER QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) PART IS SYMMETRICAL ABOUT CENTERLINE

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